

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEB
Job Number	: 27861			
Estimate Number	: 10498			
P.O. Number	: N/A		Part Number	: D2739
This Issue	: 7/11/2006	S.O. No. : N/A	Drawing Number	: D2739 REV C
Prsh Rev.	: NC		Project Number	: N/A
First Issue	: N/A		Drawing Revision	: C
Previous Run	: 27740		Material	: N/A
Written By	<u>See 1st COMMENT BELOW</u>		Due Date	: 7/30/2006
Checked & Approved By	<u>TS 06-07-11</u>		Qty:	4
Comment	: Est Rev: E 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion 'I Beam' thin Pick: Qty Part Number Description Batch 1 D2600-5 Web <u>624410</u> IT 06-07-18 (4)
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1 Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends. 5-Dburr } IT 06-07-18
3.0	QC5	INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP DP 6-7-18 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: LDDate: 26/07/25

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Tuesday, 7/11/2006 1:05:09 PM
User: Kim Johnston

Process Sheet

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Seq. #:	Machine Or Operation:	Description :
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4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1 IT 06-07-18

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 6-7-19

(41)

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock
Location: LG

DP 6-7-19

(41)

7.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

06-07-20

Job Completion



U 06-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

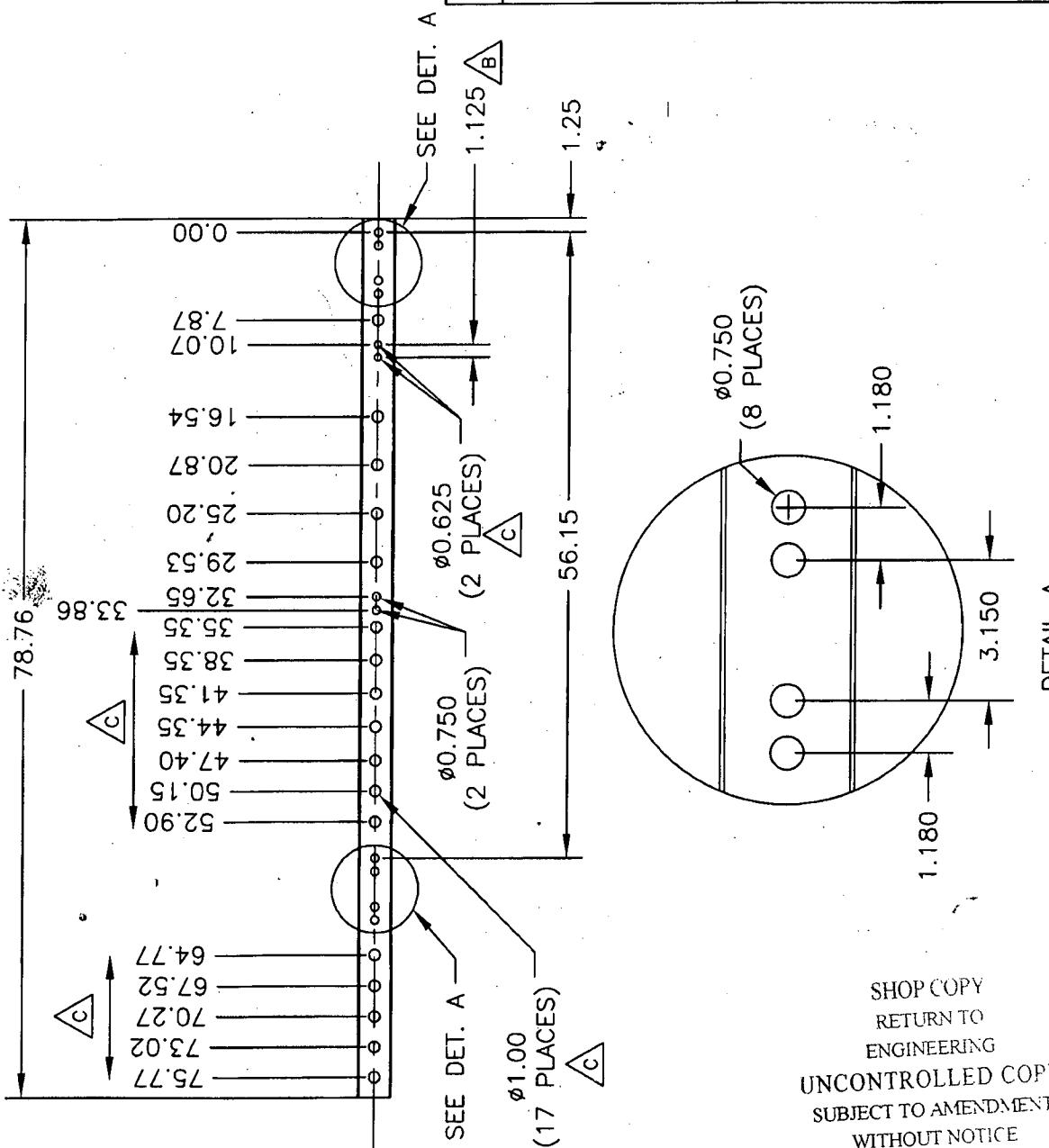
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2739	REV. C SHEET 1 OF 1
DATE 06.01.05		TITLE WEB	SCALE 1:15
A	98.04.16	NEW ISSUE	
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS	
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS	

RELEASED
do 10-20-05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27861

- D2739 WEB
1) MATERIAL:
2) FINISH:
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

